



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-667-107BL
Job Sheet 166713

South



Part No: D206-667-107BL

Job Qty: 1 ea

Part Name: Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/16/17

Job Tracking No:

Due Date: 10/16/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: Air Evac Lifeteam (CAEVA02)

Air Medical Group Holdings, Concur Invoice Capture C/O (*AEL*), 10700 Prairie Lakes Drive Eden Prairie, MN, 55344 USA ph:(636) 695-5385

Note: DWG DSI9565 REV A, DSI9628 REV A, D206-667-147 REV A (DEO), IIN-D206-667 REV D revA 11.01.13
New Issue EC verified by:DD IPP REV:B 11.08.08 PER ECN 11-615 DD VERF:EC IPP REV:C 12.08.20
DSI9628 revA (ECN12-631) DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/13/17	0.00	0.00	Start up container	
100	DC	1 pcs	10/13/17	0.00	0.00	DC	
110	Packaging	1 pcs	10/13/17	0.00	0.00	Packaging1	
120	CNC Bend Crosstubes	1 pcs	10/14/17	0.00	4.32	CNC Bend Crosstube	
130	QC	1 pcs	10/14/17	0.00	0.00	QC15	
140	Crosstubes	1 pcs	10/14/17	0.00	2.87	Crosstube	
150	HandFXtube	1 pcs	10/14/17	0.00	0.74	HandFinish5	
160	QC	1 pcs	10/14/17	0.00	0.00	QC7	DAS
170	QC	1 pcs	10/14/17	0.00	0.00	QC5	38
180	Outsource	1 pcs	10/14/17	0.00	0.00	Outsource2	9-89
190	Packaging	1 pcs	10/14/17	0.00	0.00	Packaging2	DAS
200	QC	1 pcs	10/14/17	0.00	0.00	QC5	38
210	Purchasing	1 pcs	10/14/17	0.00	0.00	Purchasing	9-89
215	Packaging	1 pcs	10/14/17	0.00	0.00	Packaging2	DAS
220	QC	1 pcs	10/14/17	0.00	0.00	QC14	38
230	Crosstubes	1 pcs	10/16/17	0.00	2.87	Crosstube	9-89 DAS
240	QC	1 pcs	10/16/17	0.00	0.00	QC5	38
250	Packaging	1 pcs	10/16/17	0.00	0.00	Packaging1	SMB 9-89
260	QC	1 pcs	10/16/17	0.00	0.00	QC4	
270	Packaging	1 pcs	10/16/17	0.00	0.00	Packaging3	
280	QC21-FG	1 Ea	10/16/17	0.00	0.00	QC21	DAS

Part Op 100 - Photocopy bluefile and create labels as per PPP D206-667-107 chg 003

Descriptions: 120 - Bend tube as per Dwg D206-667-147 using CNC bender program

140 - ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: DRZ ***** 1- Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-147. Drill all (3) top holes. Holes facing inboard. ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: DRZ ***** 2- Drill Fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-147. Note: Fwd side has 3x top holes.Facing inboard. 3- C'sink holes as per Dwg D206-667-147. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins .Drill ONLY 2 top holes ONLY plug most bottom holes to prevent accidental drilling. Drill holes and ream using drill Jig DT8541 & DT8542 as per Dwg D206-

NOV 06 2017
9-89



S001413



Fwd Crosstube – Mid Height 206L / L1 / L3 / L4, Blue

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO:
Revision:
Operation:
Quantity:
Change No:

D206 – 667 – 107BL

Start up Operation
1

Mfg Date: 10/23/17
Job No: 166713

667-147. Drill only the top (2) holes. ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: DPL ***** 5- Drill Aft rivet holes using drill Jig

150 - ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: 38151 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

210 - ISSUE PO 38200 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____

BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____ **MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per

QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____

220 - Wrap in plastic bag to protect from scratches **VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____

230 - 1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe 2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: _____ 3- Torque bolts as per dwg 4-Install nut plates as per Dwg D206-667-147. Touch-up rivet heads with Imron paint.

240 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____

260 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____

270 - Identify and pack for shipping as per PPP D206-667-107 Location:FG035

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D206-667-147TRN	1	7	0	0
	D2873-043	2	68	0	0
	D2873-045	2	65	0	0
	D2891-1	2	14	0	0
	D3595-063-395	4	64	0	0
	MS20601-AD4W8	14	327	0	0
	MS21920-20 <u>5005473</u>	4	2	0	0
250-Packaging	AN5-30A <u>5005420</u>	4	50	0	0
	AN5-32A <u>5005418</u>	4	130	0	0
	AN5-7A <u>5005417</u>	10	3,562	0	0
	<u>x4 5005413</u> AN970-4 <u>5005414 5005412 x8</u>	12	67	0	0
	D206-667-017	1	4	0	0
	MS21042L5 <u>5005410</u>	4	409	0	0
	NAS1149D0563J <u>5005408</u>	18	1,846	0	0

Part Specifications

Specifications could not be found.

Plex 10/16/17 9:03 AM dart.Michaud-Febrille.Victoria

Item	Qty -147	Part Number	Description
1	X	D206-667-147	CROSSTUBE ASSEMBLY (206L MID FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 99.84±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-147" AND BATCH NUMBER ON
INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 15.0 lbs (-507 = 12.84)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166713

17/10/14

DEO ATTACHED

ECW HK-605
11.07.28

UNDER REVIEW

RELEASED
2011-05-23
JNP

A	NEW ISSUE	CP	10.11.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D206-667-147	REV. A SHEET 1 OF 4
TITLE CROSSTUBE ASS'Y (206L MID FWD)	SCALE NTS
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8 7 6 5 4 3 2 1

D

C

B

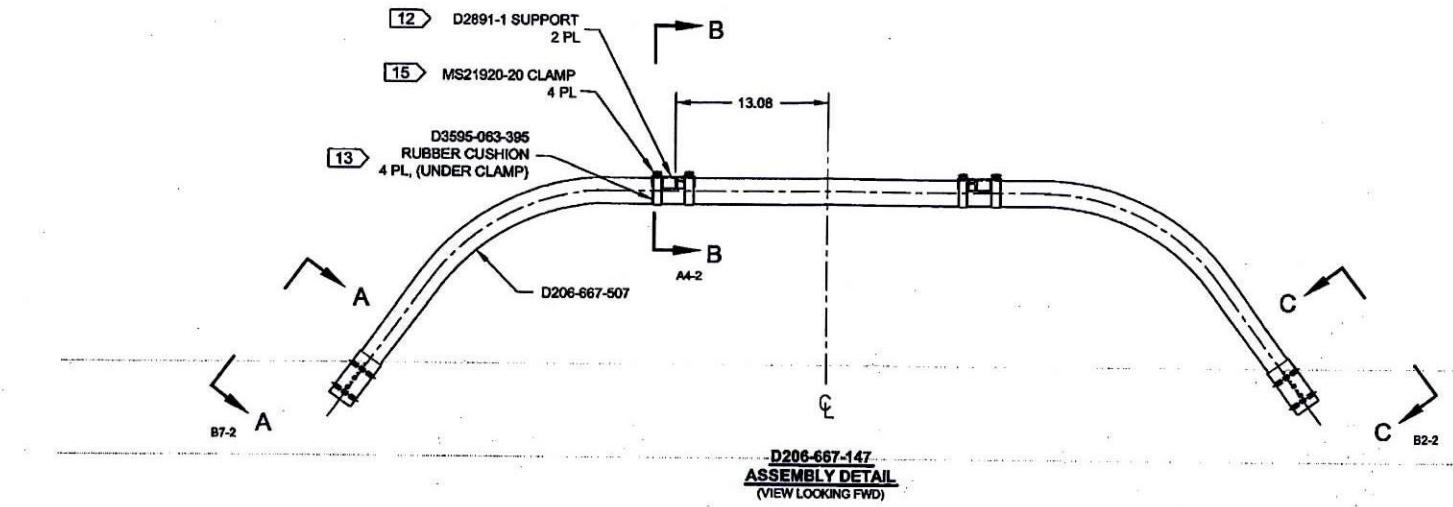
A

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C

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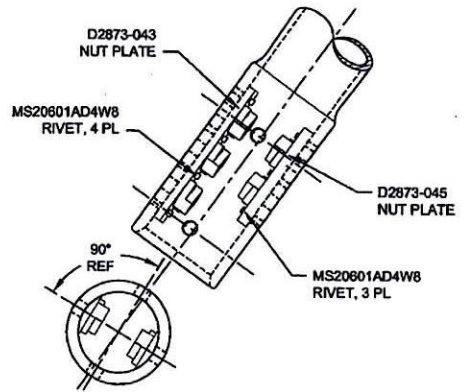
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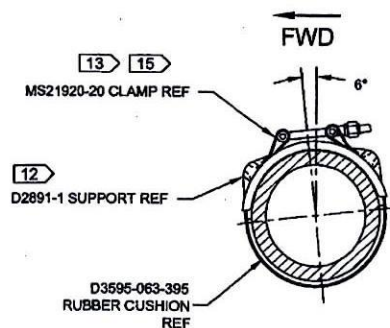
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 11.07.28
 UNDER REVIEW
 11/06/13

RELEASED
 2011-05-24

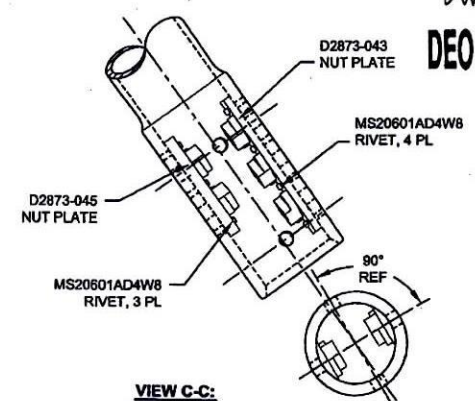
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C7-2

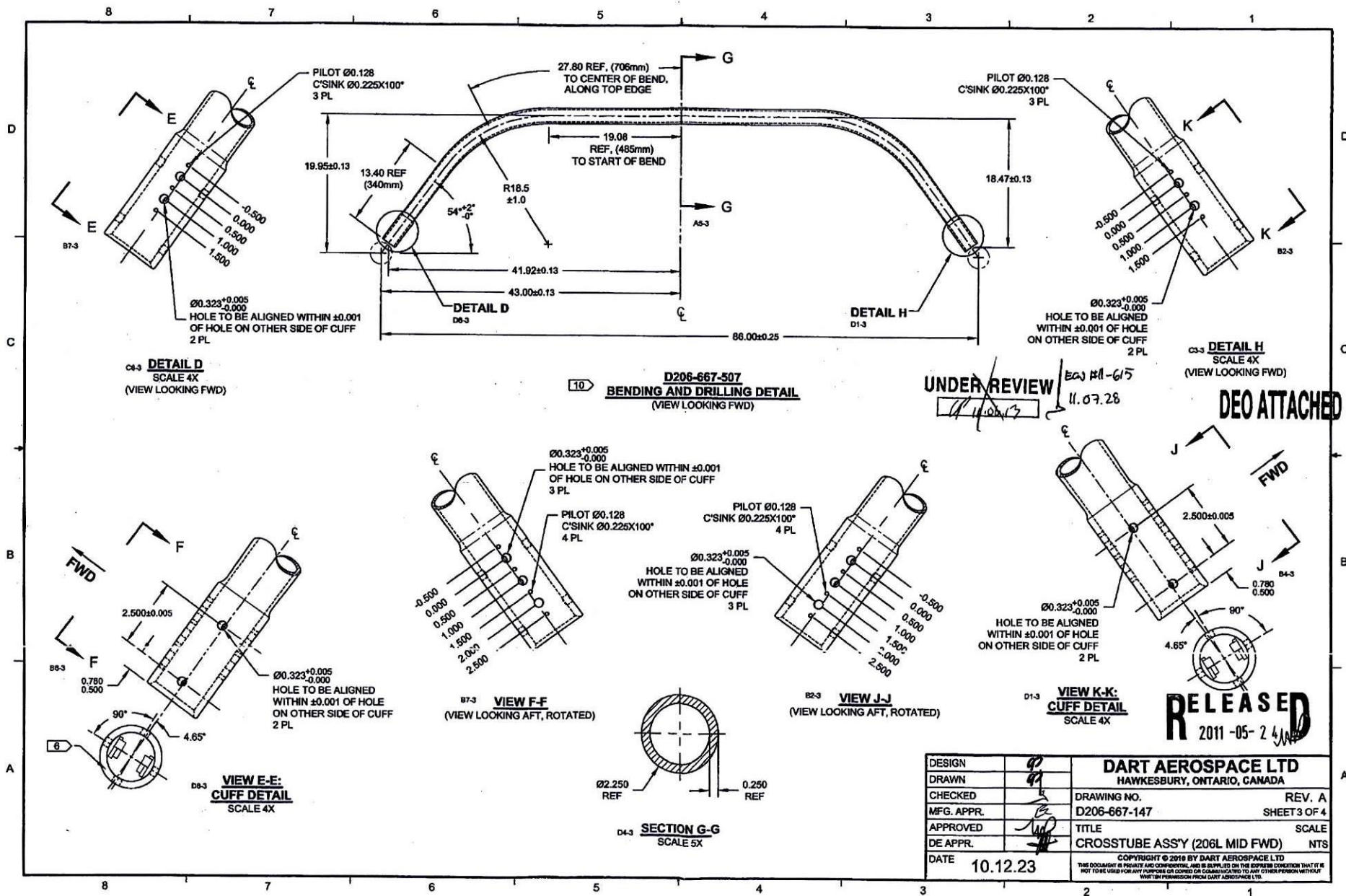


D5-2



C2-2

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D206-667-147	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L MID FWD)	NTS
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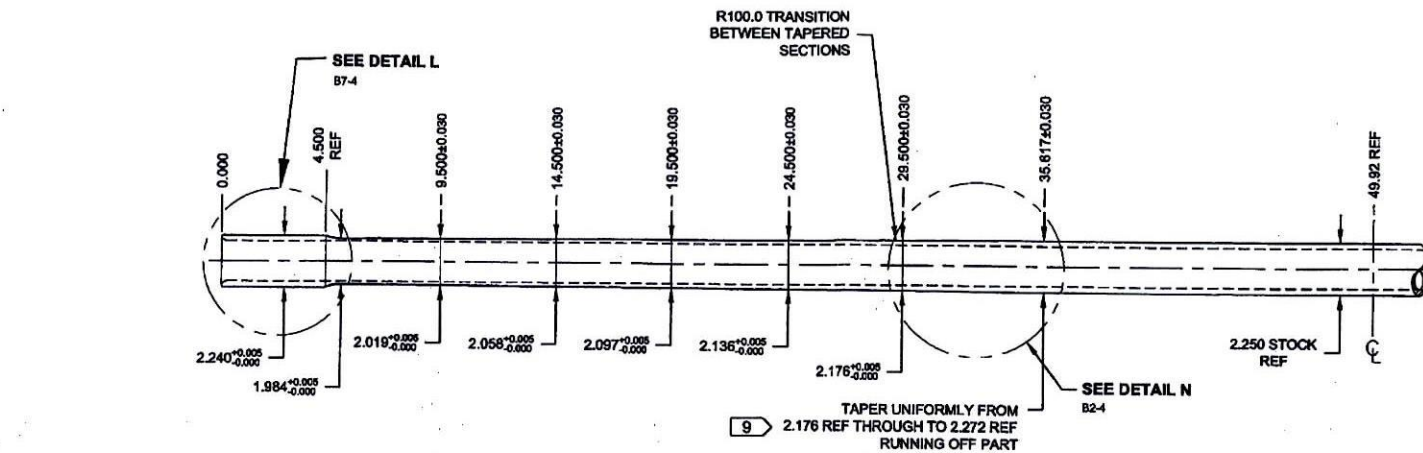
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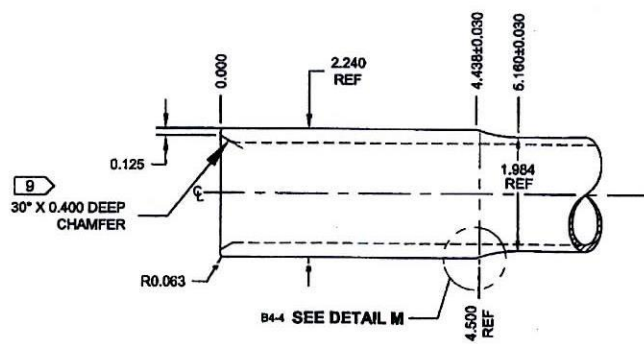
UNDER REVIEW

11.06.19

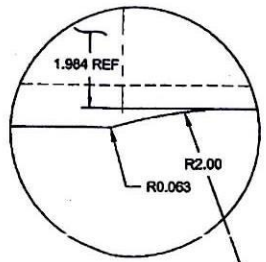
ECO # 11-615

11.07.20

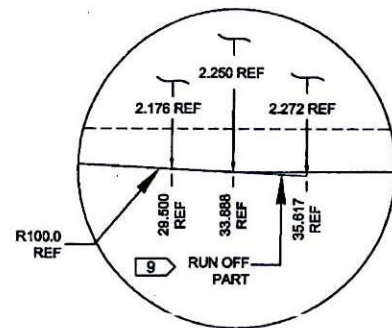
TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
D7-4
NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
A6-4
NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
C4-4
NOT TO SCALE

DEO ATTACHED

RELEASED
2011-05-13

DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D206-667-147	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L MID FWD)	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

DRAWING NO. D206-667-147	TITLE CROSSTUBE ASS'Y (206L MID FWD)	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-147-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>JB</i>	APPROVED <i>MD</i>		DE APPR. <i>MD</i>		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21		DATE 11.07.21		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -147	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRABE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
MD

DRAWING NO. D206-667-147	TITLE CROSSTUBE ASS'Y (206L MID FWD)	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-147-A-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 12.08.02	DATE 12.08.02	DATE 12.08.02	DATE 12.08.02	DATE 12.08.02	DATE 12.08.02		

PURPOSE:

ADD ELECTRICAL GROUNDING STRAP

CHANGE:

PARTS LIST:

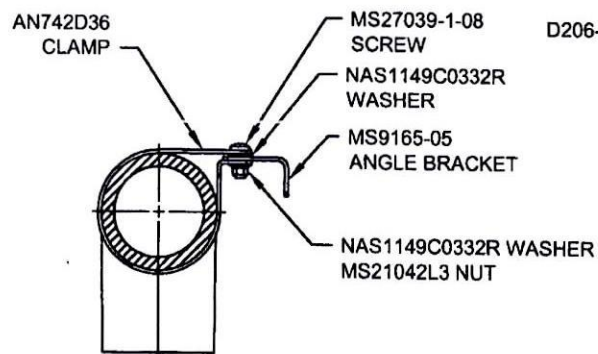
ITEM	QTY -147	PART NUMBER	DESCRIPTION
1	X	D206-667-147	CROSSTUBE ASSEMBLY (206L MID FWD)
10	2	AN742D36	CLAMP
11	2	MS9165-05	ANGLE BRACKET
12	2	MS21042L3	NUT (OR MS21042-3)
13	2	MS27039-1-08	SCREW
14	4	NAS1149C0332R	WASHER (OR AN960C10L)

GENERAL NOTES:

- 16) MASK AREA UNDER CLAMP PRIOR TO PAINTING
 17) SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-291 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT
 18) PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MILLIOHMS

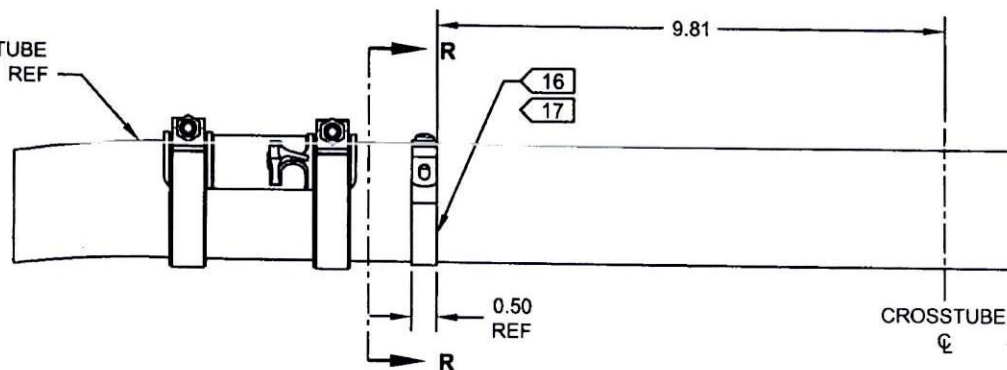
→ AFT

RELEASED
 12.08.17
 ECN 12-431



SECTION R-R

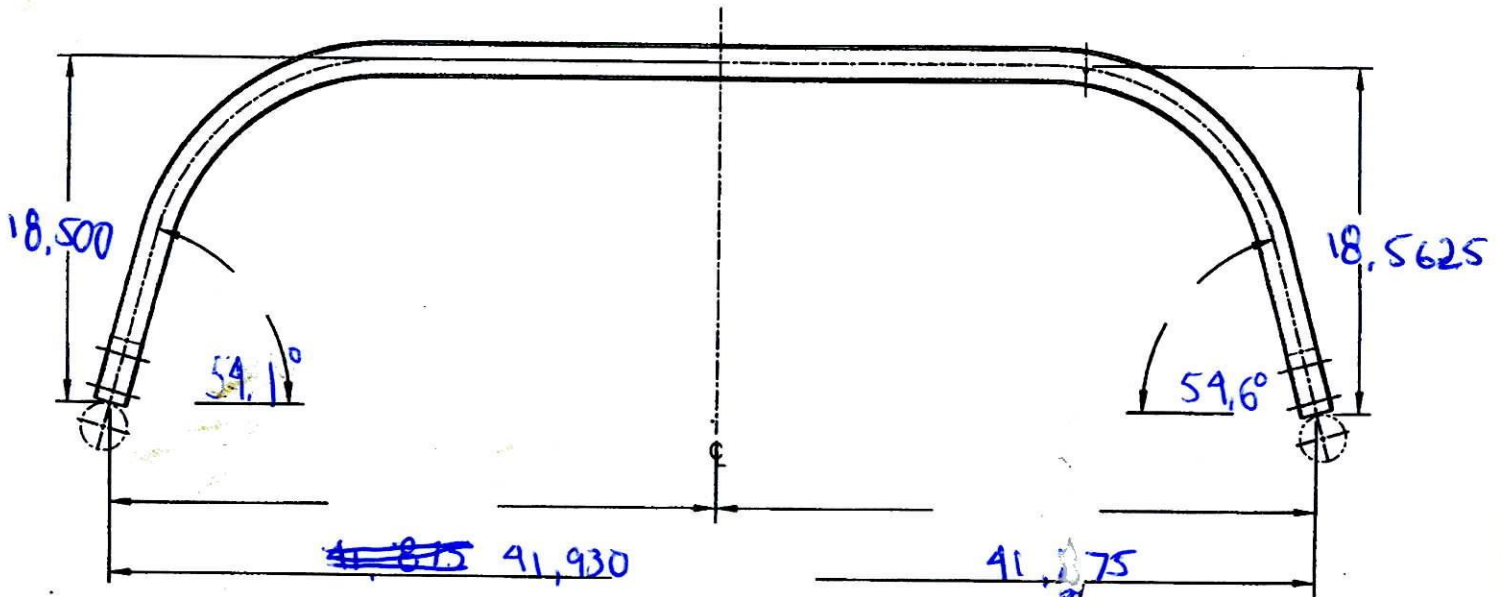
D206-667-507 CROSSTUBE REF



DETAIL P
 BONDING STRAP INSTALLATION 2 PL

DART AEROSPACE LTD		Work Order: 166713
Description: Crosstube Mid Fwd (206L)		Part Number: D206-667-107
Inspection Dwg: D206-667-147 Rev: A		Page 1 of 1

Required Dimension	Min	Max
Height	18.34	18.60
1/2 Span	41.79	42.05
Angle	54°	56°
Total Span	83.59	84.09
Bending Passes	10	--
Crushing	--	6%



	Side A	Side B
Bending Passes	14	15
Crushing	5.7%	5.5%
Comments		

QC15 Inspection	PD
Date	17.10.19

Rev	Date	Change	Revised by	Approved
A	12.02.15	New Issue	KJ	
B	12.04.16	Added bending, crushing dimensions	KJ	

2



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038151

Items

Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
				038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order								
4	166713	D206- 667- 107BL	-	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order		Firmed	10/31/17	1 pcs	0 pcs	1 pcs	\$110.41666/pcs	\$110.42
								OCT 3 1 2017		DAS 13 9-59		
5	166591	D206- 667- 207BL	-	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order		Firmed	10/31/17	1 pcs	0 pcs	1 pcs	\$110.41666/pcs	\$110.42
								OCT 3 1 2017		DAS 13 9-59		
6	166593	D206- 667- 207BL	-	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order		Firmed	10/31/17	1 pcs	0 pcs	1 pcs	\$110.41666/pcs	\$110.42
								OCT 3 1 2017		DAS 13 9-59		
7	166589	D206- 667- 207BL	-	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue		Firmed	10/31/17	1 pcs	0 pcs	1 pcs	\$110.41666/pcs	\$110.42

NDT MWO33757 ON 12 CROSSTUBES**Task: 1 MWO33757****Problem:**

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 12 CROSSTUBES

ITEM ID: D206-667-107BL FWD CROSSTUBE - MID HEIGHT 206L /L1/L3/L4 BLUE (QTY4)

1 - WORK ORDER ID#: 166713

2 - WORK ORDER ID#: 166858

3 - WORK ORDER ID#: 166859

4 - WORK ORDER ID#: 166578

ITEM ID: D206-667-207BL AFT CROSSTUBE - MID HEIGHT 206L /L1/L3/L4 BLUE (QTY8)

5 - WORK ORDER ID#: 166586

6 - WORK ORDER ID#: 166595

7 - WORK ORDER ID#: 166587

8 - WORK ORDER ID#: 166593

9 - WORK ORDER ID#: 166594

10 - WORK ORDER ID#: 166591

11 - WORK ORDER ID#: 166589

12 - WORK ORDER ID#: 166592

Action Taken:

LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-12) AS PER ASTM1417M-13

NO CRACK FOUND

Pen: ZL-27A MWO5678 DEV: SKD-S2 MPO11715 CLEANER: SKC-S MPO13923

Total For This Task:

.00

NDT MWO33757 ON 12 CROSSTUBES - Fixed Labor

1

1,325.00

Labor:**1,325.00****NDT MWO33757 ON 12 CROSSTUBES Total:****1,325.00****Totals:****Sub-Total:****1,325.00 CAD****HST ON:****172.25 CAD****Total Charges:****1,497.25 CAD**

G.S.T. Registration Number 14149 4898 RT0001

Q.S.T. Registration Number 1019297914 TQ0001

BC P.S.T. Registration number: PST-1008-4786



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-667-107BL
Job Sheet 166713



Part No: D206-667-107BL

Job Qty: 1 ea

Part Name: Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue

5001413



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/16/17

Job Tracking No:

Due Date: 10/16/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: Air Evac Lifetech (CAEVA02)

Air Medical Group Holdings, Concur Invoice Capture C/O (*AEL*), 10700 Prairie Lakes Drive Eden Prairie, MN, 55344 USA ph:(636) 695-5385

Note: DWG DSI9565 REV A, DSI9628 REV A, D206-667-147 REV A (DEO), IIN-D206-667 REV D revA 11.01.13
New Issue EC verified by:DD IPP REV:B 11.08.08 PER ECN 11-615 DD VERF:EC IPP REV:C 12.08.20
DSI9628 revA (ECN12-631) DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/13/17	0.00	0.00	Start up container	
100	DC	1 pcs	10/13/17	0.00	0.00	DC	
110	Packaging	1 pcs	10/13/17	0.00	0.00	Packaging1	
120	CNC Bend Crosstubes	1 pcs	10/14/17	0.00	4.32	CNC Bend Crosstube	
130	QC	1 pcs	10/14/17	0.00	0.00	QC15	
140	Crosstubes	1 pcs	10/14/17	0.00	2.87	Crosstube	
150	HandFXtube	1 pcs	10/14/17	0.00	0.74	HandFinish5	
160	QC	1 pcs	10/14/17	0.00	0.00	QC7	DA6
170	QC	1 pcs	10/14/17	0.00	0.00	QC5	38
180	Outsource	1 pcs	10/14/17	0.00	0.00	Outsource2	9-89
190	Packaging	1 pcs	10/14/17	0.00	0.00	Packaging2	
200	QC	1 pcs	10/14/17	0.00	0.00	QC5	
210	Purchasing	1 pcs	10/14/17	0.00	0.00	Purchasing	
215	Packaging	1 pcs	10/14/17	0.00	0.00	Packaging2	
220	QC	1 pcs	10/14/17	0.00	0.00	QC14	
230	Crosstubes	1 pcs	10/16/17	0.00	2.87	Crosstube	Dr. 17-10-31
240	QC	1 pcs	10/16/17	0.00	0.00	QC5	
250	Packaging	1 pcs	10/16/17	0.00	0.00	Packaging1	
260	QC	1 pcs	10/16/17	0.00	0.00	QC4	
270	Packaging	1 pcs	10/16/17	0.00	0.00	Packaging3	
280	QC21-FG	1 Ea	10/16/17	0.00	0.00	QC21	

Part Op 100 - Photocopy bluefile and create labels as per PPP D206-667-107 chg 003

Descriptions: 120 - Bend tube as per Dwg D206-667-147 using CNC bender program

140 - ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: DPZ ***** 1- Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-147. Drill all (3) top holes. Holes facing inboard. ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: DPZ ***** 2- Drill Fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-147. Note: Fwd side has 3x top holes.Facing inboard. 3- C'sink holes as per Dwg D206-667-147. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins .Drill ONLY 2 top holes ONLY plug most bottom holes to prevent accidental drilling. Drill holes and ream using drill Jig DT8541 & DT8542 as per Dwg D206-

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667-147. Drill only the top (2) holes. ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: DOL ***** 5- Drill Aft rivet holes using drill Jig

150 - ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

210 - ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____

220 - Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

230 - 1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe 2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: 138408 3- Torque bolts as per dwg 4-Install nut plates as per Dwg D206-667-147. Touch-up rivet heads with Imron paint. exp 3/11

240 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

260 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

270 - Identify and pack for shipping as per PPP D206-667-107 Location:FG035

Sitaflex 138555 exp 3/18

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D206-667-147TRN	1	7	0	0
	D2873-043 <u>F164360</u>	②	68	0	0
	D2873-045 <u>F164501</u>	②	65	0	0
	D2891-1 <u>164353</u>	②	14	0	0
	D3595-063-395 <u>166073-157</u>	④	64	0	0
	MS20601-AD4W8 <u>500554</u>	④	327	0	0
	MS21920-20 <u>L38246</u>	④	2	0	0
	AN5-30A	4	50	0	0
	AN5-32A	4	130	0	0
	AN5-7A	10	3,562	0	0
250-Packaging	AN970-4	12	67	0	0
	D206-667-017 <u>165588</u>	①	4	0	0
	MS21042L5	4	409	0	0
	NAS1149D0563J	18	1,846	0	0

Part Specifications

Specifications could not be found.